

Work Order ID 87024

87024

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Monday, July 09, 2012 9:17:05 PM

Item ID: D4522-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Base, Vertical Swing Arm

Start Date: 7/10/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/19/2012 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4522	B

100		0.00							
100		0.00							
Bandsaw	Memo								
Jeaspa Bandsaw	CUT BLANK AT 1.875"								

110		0.00							
110		0.00							
HAAS 1	Memo								
HAAS CNC vertical machine #1	MACHINE AS PER DWG & FOLIO FB105								
	FOLIO REV: <u>AN</u>								
	DWG REV: <u>25</u>								

DEBURR

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Item ID: D4522-047

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Start Date: 7/10/2012 Start Qty: 2.00

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Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

29 12.7.12

2

4

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DA
14
28

12/07/16

2

4

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

2

28 12-7-16

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							 12/07/17
160 *160* Small Fab Small Fab	Memo INSERT HELI-COIL	0.00 0.00				(2)	Ø		FF 12-07-17
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(42)			 12/07/17

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

Identify as per dwg & Stock Location: ST 117 0.00***180***

Packaging

Memo

0.00

Packaging

2xSP
12-7-17

190

QC21 - Final Inspection - Work Order Release 0.00

190

QC

Memo

0.00

Quality Control

12/7/19MF
12-07-18

Picklist Print

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Work Order ID: 87024

Parent Item: D4522-047

Parent Item Name: Base, Vertical Swing Arm

Start Date: 7/10/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-02-18 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.250 6061-T6 Bar 2.00 x 1.25		Purchased	No				f	46.8001		0.332		B.A 12/07/10	

Location

Loc Qty

Loc Code

MAT009

10.8

→ 121660

10.8

MAT010

36.00006358

121040

0.00006358

122321

36

MS21209-C0820

Purchased

No

Each

10.0000

Threaded Insert, 8-32 UNC x 0.33 LG

Location

Loc Qty

Loc Code

ST305

10

120593

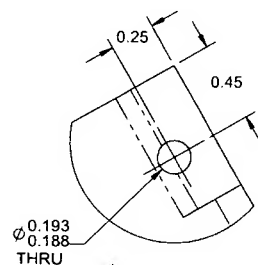
10

0.332 ft

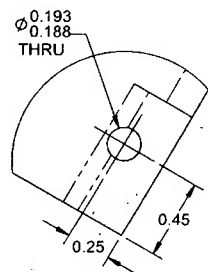
4 Jul 12-07-16
② FF 12-07-17

24

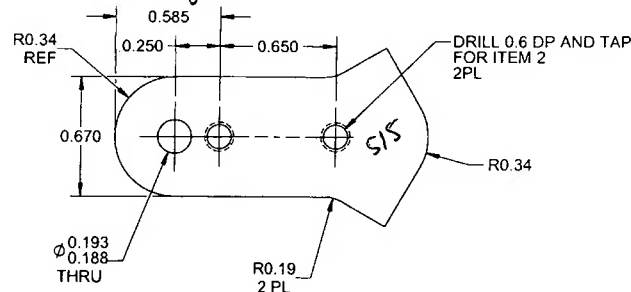
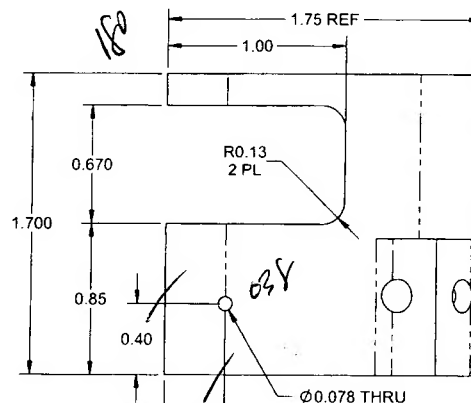
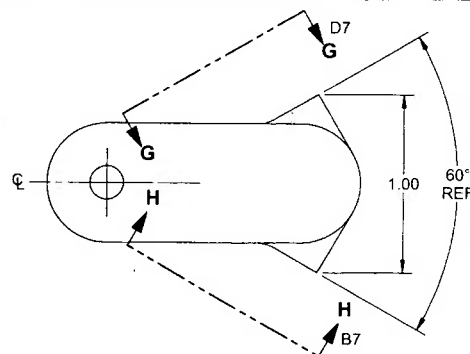
ITEM	QTY	P/N	DESCRIPTION
	X	D4522-047	BASE, VERTICAL SWING ARM
1	1	D4522-5	BASE, VERTICAL SWING ARM
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



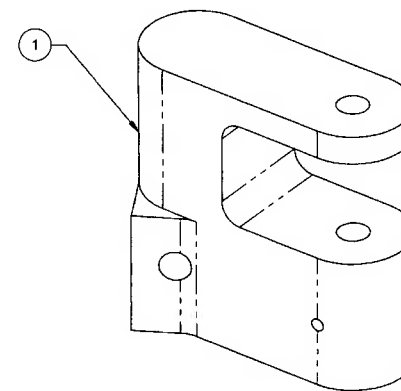
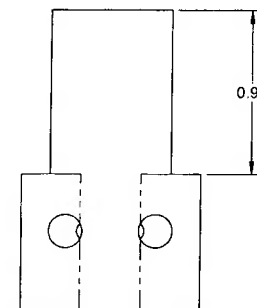
VIEW G-G D4



VIEW H-H C4






D4522-047 BASE, VERTICAL SWING ARM



- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
 - 7) WEIGHT: 0.14 lbs

RELEASED
2012-06-13

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV.
MFG. APPR.		D4522	SHEET 10 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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174/2 = 87 187/2 = 93.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

